

213/214

Work Order ID 51841

September 4, 2009 10:10:57 AM



Item ID: D3901-1

Accept



Setup Start



Revision ID: B

Item Name: Bar

Stop



Start Date: 09/04/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-09-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3901	B								
100		0.00							
	Waterjet								
FLOW CNC Waterjet	Memo LOW WATER JET 1-Cut as per Dwg D3901 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary	0.00							
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

12 9-9-14

4

1B 9-9-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

=> Sorbolis

QC

Memo

0.00

FCL

Quality Control

130

Small Fab

Small Fab

Memo

SMALL & MEDIUM FAB RESOURCE 1
1-drill holes as per dwg D3806
2-deburr

0.00

0.00

a/a Sorbolis

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

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Page 3

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Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: *W/A*

0.00



Packaging

Memo

0.00

Packaging

4

EL

9-9-16

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/16

W 09-09-16

W/O:		WORK ORDER CHANGES					
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Picklist Print

September 4, 2009 10:10:57 AM

Page 1

Work Order ID: 51841



Parent Item: D3901-1RevB



Parent Item Name: Bar

Start Date: 09/04/2009

Required Date: 09/11/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B0.500X012.000		Purchased	No			100	sf	12.0000	0.2020	140.40		



WB 9-9-14

304 BAR .500 X 12.00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

12

111722

12

111722

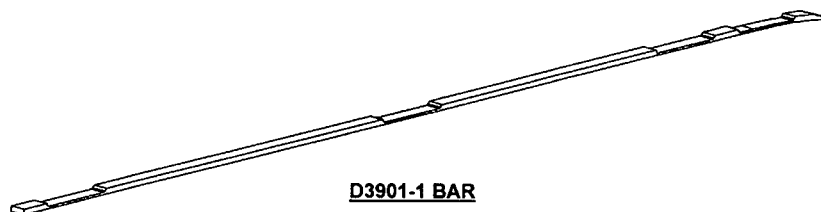
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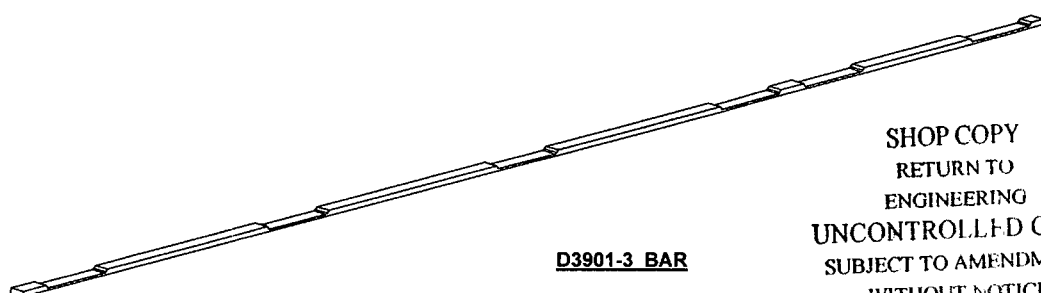
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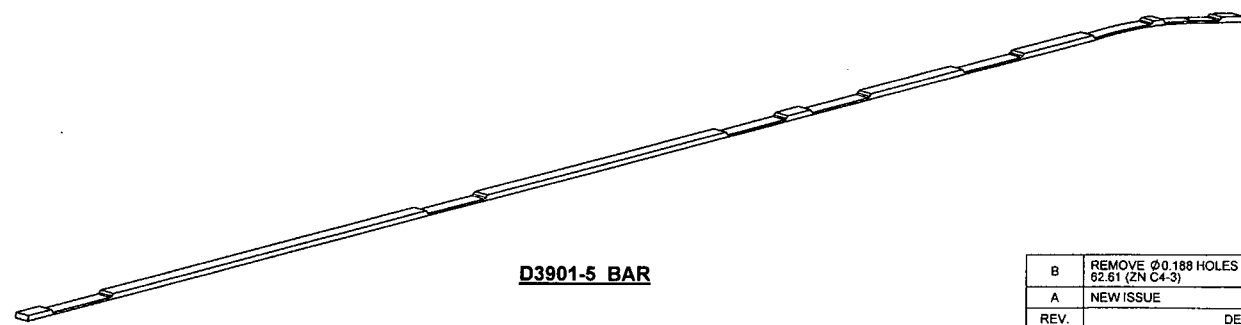
NOTE: Date & initial all entries



D3901-1 BAR



D3901-3 BAR



D3901-5 BAR

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51841
ME
09-09-04.

RELEASED
09/07/15 M

B	REMOVE Ø0.188 HOLES FROM D3901-1/-3/-5; 62.12 WAS 62.51 (2N C4-3)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>AB</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>E</i>	D3901	SHEET 1 OF 4
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>J</i>	BAR	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

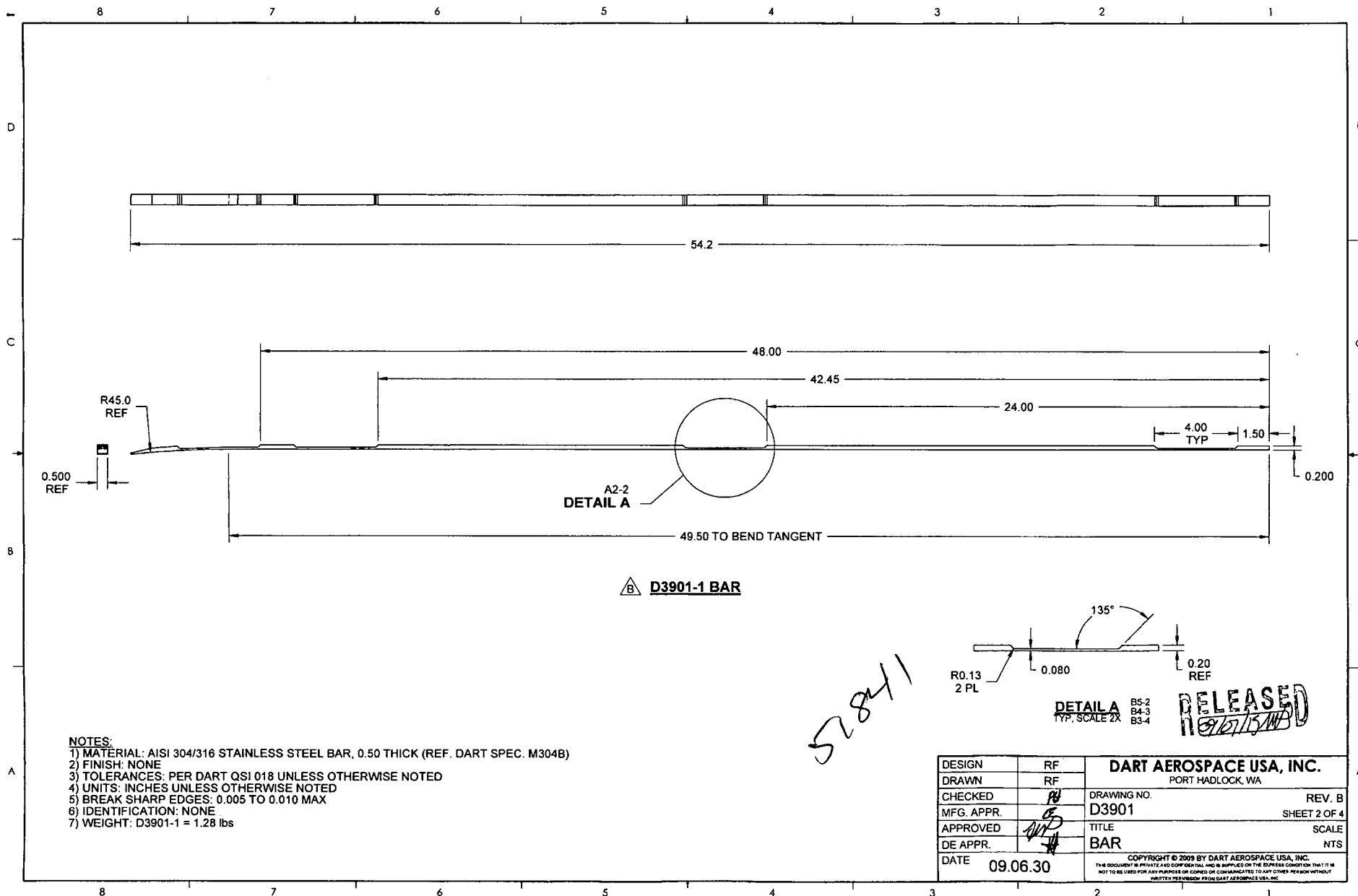
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8 7 6 5 4 3 2 1

D

D

C

C

B

B

A

A

0.50
REF

1.50

4.00
TYP

16.00


31.00

62.12

B

0.20

DETAIL A
A2-2




 **D3901-3 BAR**

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.50 THICK (REF. DART SPEC. M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3901-3 = 1.53 lbs

51841

RELEASED
09/07/13

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO. D3901	REV. B SHEET 3 OF 4
MFG. APPR.		TITLE BAR	SCALE NTS
DE APPR.		COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DATE	09.06.30		

8 7 6 5 4 3 2 1

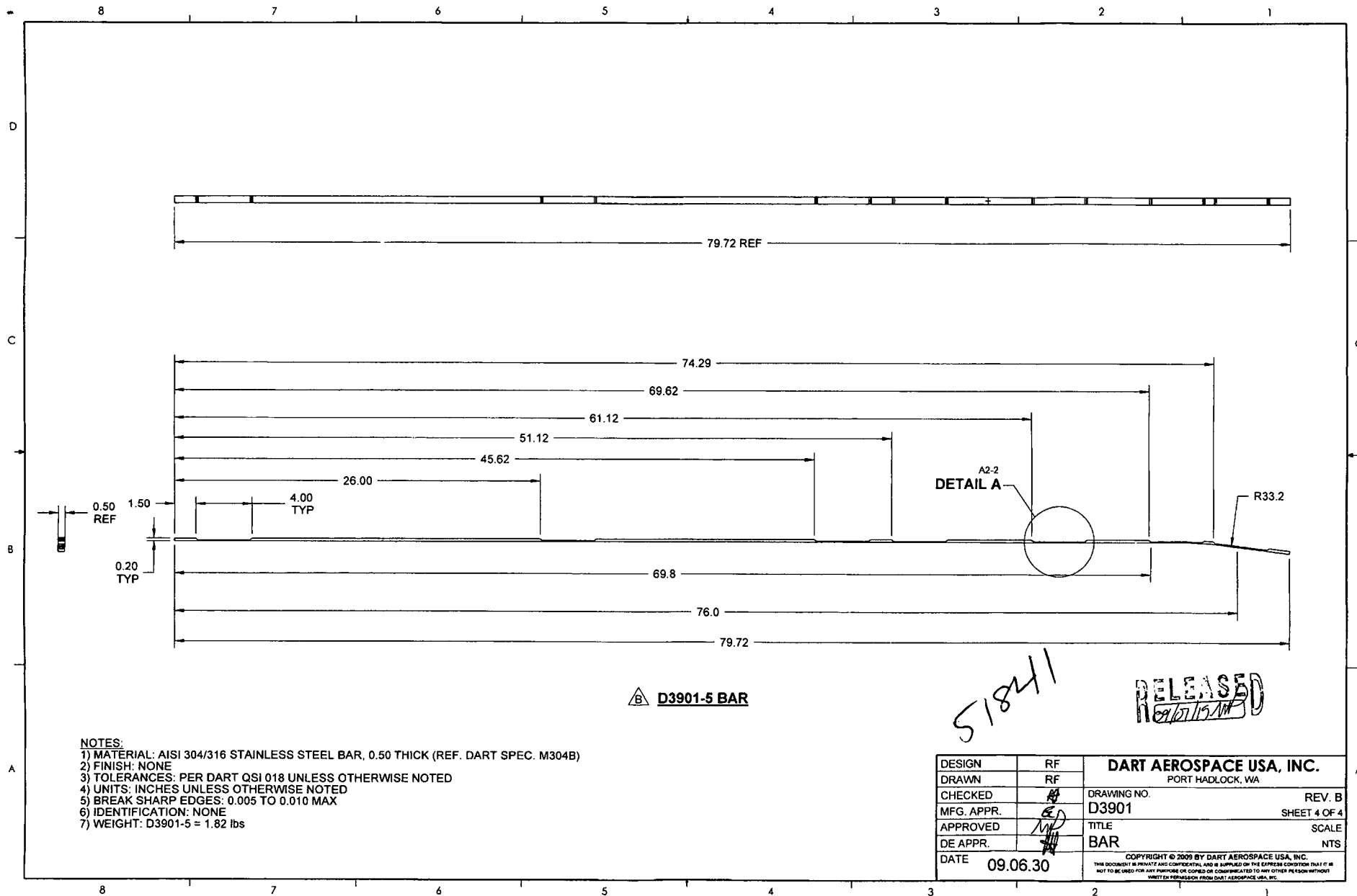
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